

Date: Wednesday, 03/09/2008 10:26:03 AM
 User: Julie Lecocq

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services			Drawing Name	: 206/OH-58 SADDLE, OUTBOARD, LEFT SIDE		
Job Number	: 41721			Part Number	: D29321UP		
Estimate Number	: 12924			Drawing Number	: D2932 REV C		
P.O. Number	:			Project Number	: N/A		
This Issue	: 03/09/2008 S.O. No. :			Drawing Revision	: C		
Prsht Rev.	: NC			Material	:		
First Issue	: / / Type : MACHINED PARTS			Due Date	: 26/09/2008 Qty: 3 Um: Each		
Previous Run	: 35226						
Written By	:						
Checked & Approved By	: <u>JUL 08.9.03</u>						
Comment	: Est Rev:A New Issue 07-07-04 JLM						

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	D6101003	Saddle Billet, 7075	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s) 7075-T7351 2X6.25X7.875 Issue material from stock: 7075-T7351 Cut Size 2.0 x 6.25 X 7.880 Grain Along Long 7.88 Length Batch No: <u>63552 834873</u>	
2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1	
		Comment: HAAS CNC VERTICAL MACHINING #1 Program part number and batch number. 1-Inspect part number and batch number are programmed correctly. 2-Machine Step No 1 of Folio and visually inspect as per dwg D2932 & attached Dimension Sheet 3-Machine Step No 2 of Folio and visually inspect as per dwg D2932 & attached Dimension Sheet 4-Machine Step No 3 of Folio and visually inspect as per dwg D2932 & attached Dimension Sheet 5-Deburr & TUMBLE	
3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE	
		Comment: CONVENTIONAL MILLING MACHINE Machine Keyway and inspect per attached dimension sheet	
4.0	QC1	INSPECT ALL DIM TO DIM SHEET	
		Comment: INSPECT ALL DIM TO DIM SHEET	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Seq. #: Machine Or Operation:

Description :

5.0 QC8 SECOND CHECK



Comment: SECOND CHECK

J.F. 08/09/08 (3)

6.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

08.04.08 (3)

7.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

Fix 08/09/08 (3)

8.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST 438

AS 08/09/08 (3)

9.0 QC21 FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/09/08 (3)

Job Completion



U 08.09.08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD				Work Order:	411721
Description: 206 Saddle, Outboard, Left side				Part Number:	D2932-1
Inspection Dwg: D2932 Rev. C				Page 1 of 1	

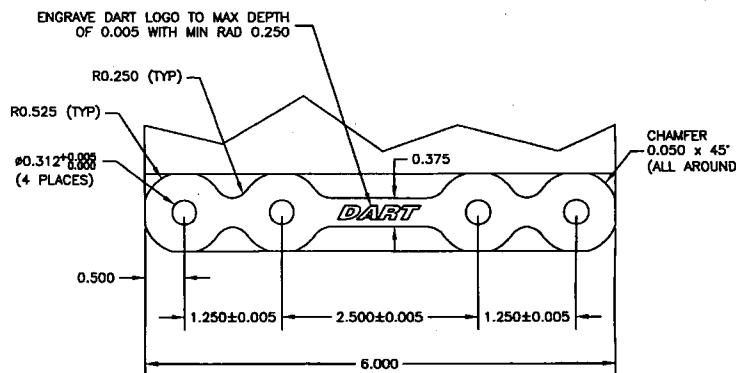
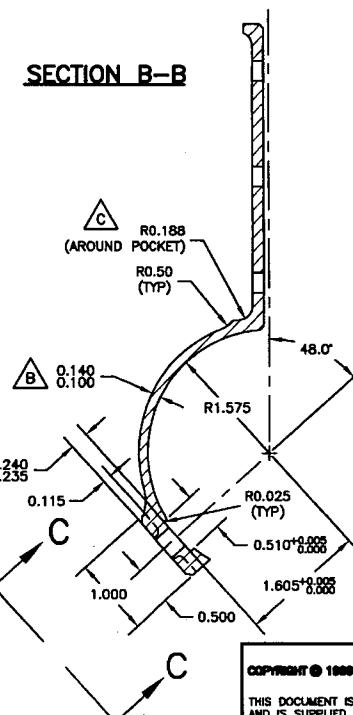
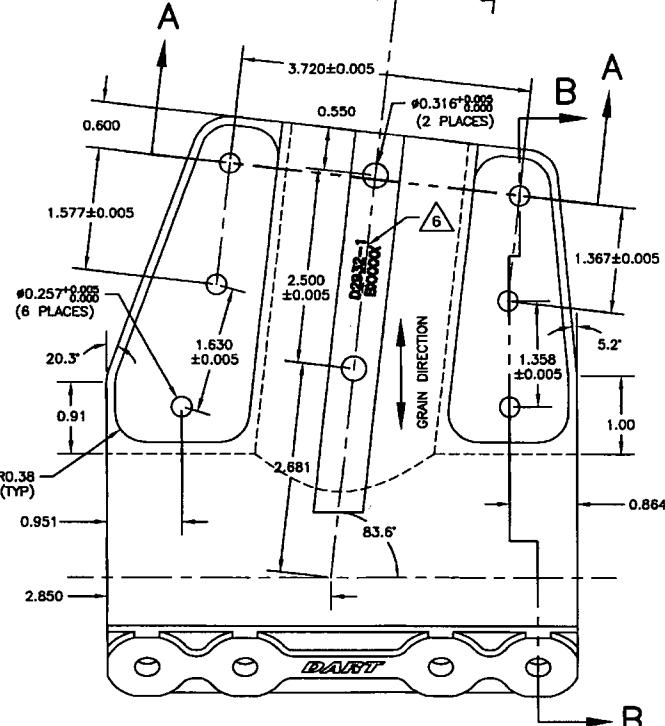
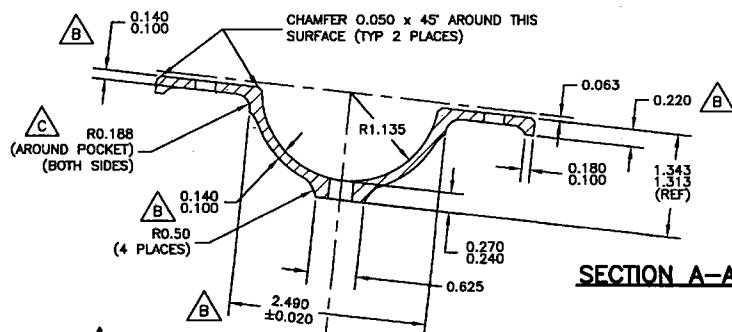
Inspect dimensions highlighted on inspection sheet drawing D2932 Rev. C and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.100	0.140		.118	.119	.118			
B	0.100	0.140		.119	.120	.118			
C	0.100	0.140		.122	.123	.121			
D	0.210	0.230		.223	.223	.224			
E	1.245	1.255		1.250	1.250	1.250			
F	1.245	1.255		1.250	1.250	1.250			
G	2.495	2.505		2.500	2.500	2.500			
H	0.510	0.515		.510	.510	.510			
I	1.572	1.582		1.577	1.577	1.577			
J	2.495	2.505		2.495	2.500	2.500			
K	0.257	0.262		.258	.258	.258			
L	0.312	0.317		.317	.313	.313			
M	0.235	0.240		.238	.238	.238			
N	0.100	0.140		.122	.122	.122			
O	0.540	0.560		.547	.547	.548			
P	0.490	0.510		.505	.504	.504			
Q	3.715	3.725		3.720	3.720	3.720			
R	2.470	2.510		2.482	2.492	2.491			
S	0.240	0.270		.250	.251	.251			
T	0.100	0.180		.140	.140	.140			
U	1.625	1.635		1.630	1.630	1.630			
V	1.362	1.372		1.370	1.370	1.370			
W	0.316	0.321		.321	.322	.321			
X	1.125	1.145		1.139	1.138	1.138			
Y	1.565	1.585		1.569	1.573	1.571			
Z	0.178	0.198		.188	.188	.188			
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by: J.F.
Date: 08/09/07

Audited by: J.F.
Date: 08/09/07

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM <u>JLM</u>	<u>JLM</u>



D2932-1 LH SADDLE (SHOWN)
D2932-2 RH SADDLE (OPPOSITE)

NOTES:

- 1) MATERIAL: ALUMINUM 7075-T7351 (QQ-A-250/12)
(MAKE FROM D6101-003 SADDLE BILLET, 7075)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
- 3) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) ENGRAVE PART AND BATCH NUMBER IN THIS AREA 0.010 TO 0.015 DEEP

C	06.11.09	R0.188 WAS R0.30 TO R0.25
B	00.05.29	CHANGED GEOMETRY AND MATERIAL
A	99.10.29	NEW ISSUE
DESIGN	4	DRAWN BY CB
CHECKED	4	APPROVED 4
		DART AEROSPACE USA, INC. BELLEVUE, WA
		REV. 6 D2932 SHEET 1 OF 1
DATE	06.11.09	SCALE 2:3
		TITLE SADDLE OUTSIDE

RELEASED
by [Signature]
C-1
NO. 4721
SUBJECT TO AMENDMENT
WORK ORDER
NO. 4721
UNCONTROLLED COPY
WITH OUT NOTICE
ENGINEERING
RETURN TO
SHOP COPY

